



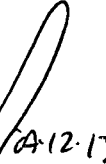


Process Sheet

Form: rprocess

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 08/01/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07/12/13	3.0	Tube had been stripped & re Painted, but the paint spots of old paint were missed and painted over, on the cuff sections.	 QS1412	Sand x-tube and re-paint as per QSi005, as per	 07/12/13	 07/12/20	 QS1412	 QA12-13

NOTE: Date & initial all entries

Date: Wednesday, 12/5/2007 3:43:46 PM
User: Kim Johnston

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D407667105A

Job Number: 36158

Part Number: D407667105

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7/12/20 (41)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

REPACKAGE PER PPP

USING NEW B/N

ENSURE ORIGINAL KIT IS IN BOX.

Rec B 7/12/27 SP

7/12/00 SP (1X)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

12/08/01/03

Job Completion



2008/1/13 C2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED DS	DRAWING NO. D407-667-145	REV. B SHEET 1 OF 3
DATE 05.07.26		TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE NTS
A	02.05.08	NEW ISSUE	
B	05.07.26	ADD HOLES AND NUT PLATES FOR COMPATABILITY WITH BHT/AA SKIDTUBES	

RELEASED
05.07.26

UNDER REVIEW
06-08-10 PH
re-draw detail
PH
07.06.19

Qty	Part Number	Description
X	D407-667-145	CROSSTUBE ASSEMBLY (407 HIGH FWD)
1	D6010-115	CROSSTUBE
2	D2856-400-694	ABRASION STRIP
2	D2873-043	NUT PLATE
2	D2873-045	NUT PLATE
2	D2891-1	SUPPORT
14	MS20601AD4W10	RIVET (OR NAS9302B-4-10)
4	MS21920-20	CLAMP

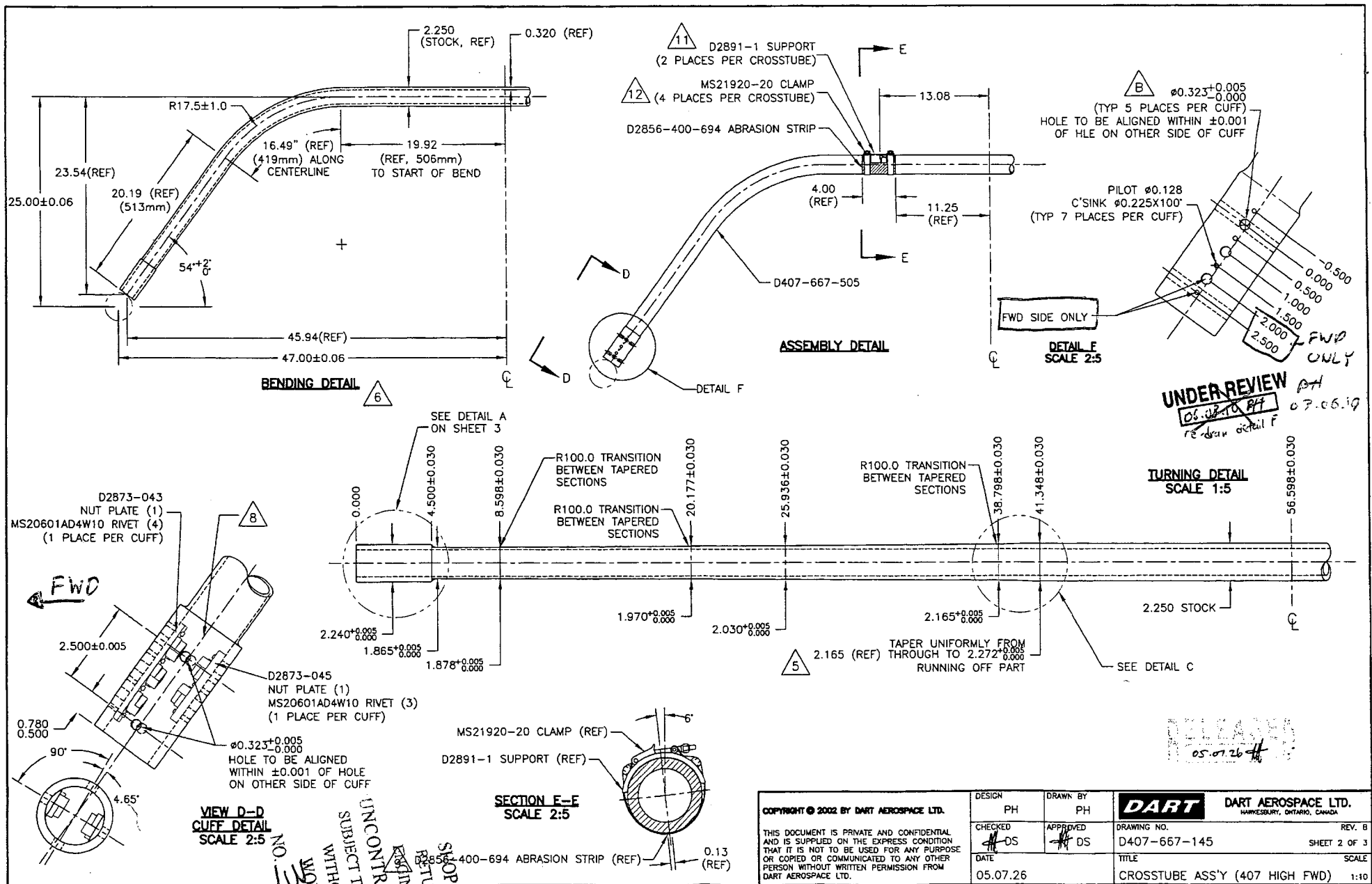
GENERAL NOTES:

- 1) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 2) MATERIAL: MANUFACTURED FROM D6010-115
FINISHED LENGTH = 113.20 ± 0.020
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
PRIME INSIDE AND OUTSIDE PER DART QSI 005 4.2
PAINT OUTSIDE PER DART QSI 005 4.2
- 4) PART IS SYMMETRIC ABOUT CENTERLINE.
- 5) RUN-OFF PART. BLEND OUT EDGE LONGITUDINALLY, TRANSITION SHOULD BE SMOOTH.
- 6) BEND PROGRESSIVELY WITH A MINIMUM OF 6 PASSES. MAXIMUM TUBE FLATTENING DUE TO BENDING IS 6% BASED ON O.D.
- 7) LIQUID PENETRANT INSPECT OUTSIDE SURFACE OF CROSSTUBE PER QSI 038.
- 8) SCRIBE DART PART NUMBER AND BATCH NUMBER IN THIS AREA WITH VIBRATING STYLUS.
- 9) INSTALL D2856-400-694 ABRASION STRIP WITH A 0.13 (REF) GAP ON BOTTOM SIDE OF CROSSTUBE, CENTERED OPPOSITE D2891-1 SUPPORT, PER QSI 035.
- 10) EXTREME CARE MUST BE TAKEN TO PROTECT THE OUTSIDE SURFACE OF THE TUBE. THE OUTSIDE SURFACE MUST BE SMOOTH AND FREE FROM SURFACE DEFECTS SUCH AS SCRATCHES, NICKS, OR DENTS. DEFECTS UP TO 0.005" MAY BE BLENDED OUT LONGITUDINALLY. CIRCUMFERENTIAL GRIND MARKS ARE UNACCEPTABLE.
- 11) SEAL EDGES OF SUPPORTS AND ABRASION STRIP USING SIKAFLEX-241/291 SEALANT (OPTIONAL).
- 12) TORQUE CLAMPS 80 TO 100 IN-LB.

SHOP COPY
RETURN TO
ENGINEERING
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
36158

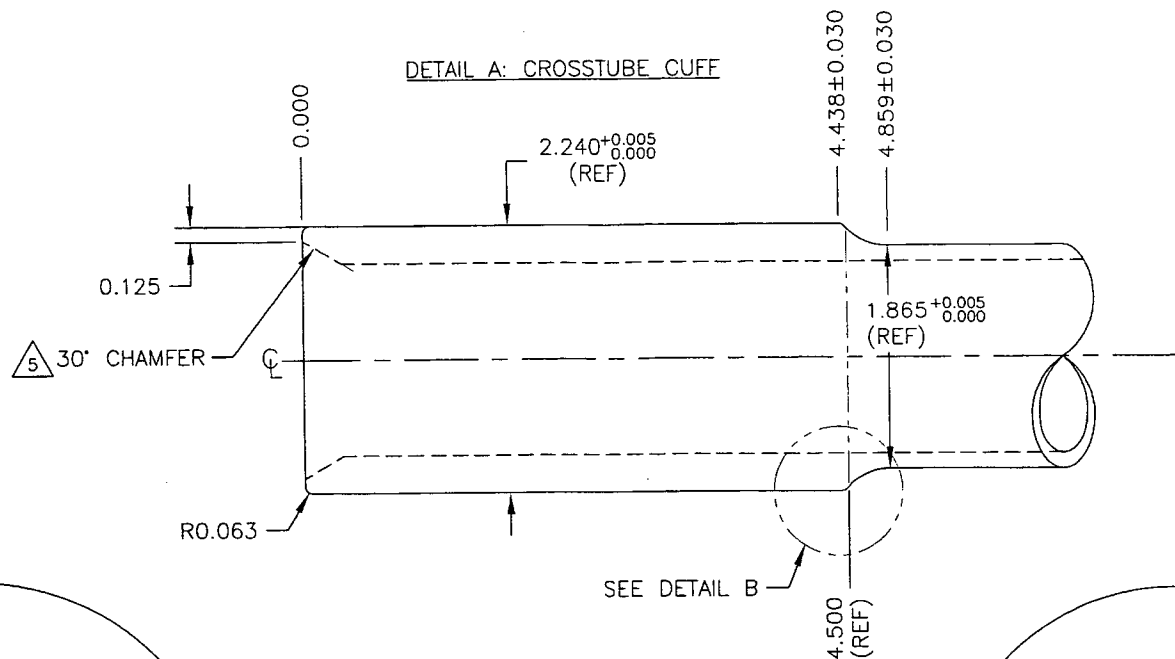
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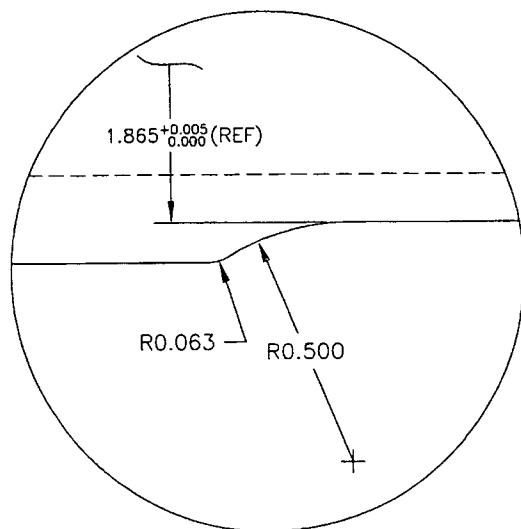
COPYRIGHT © 2002 BY DART AEROSPACE LTD.		DESIGN	PH	DRAWN BY	PH	DART	DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED	DS	APPROVED	DS	DRAWING NO.	REV. B
		DATE	05.07.26			D407-667-145	SHEET 2 OF 3
						TITLE	SCALE
						CROSSTUBE ASS'Y (407 HIGH FWD)	1:10

NO. 36158
 WORK ORDER
 SUBJECT TO AMENDMENT
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 RETURN TO
 STOP COPY

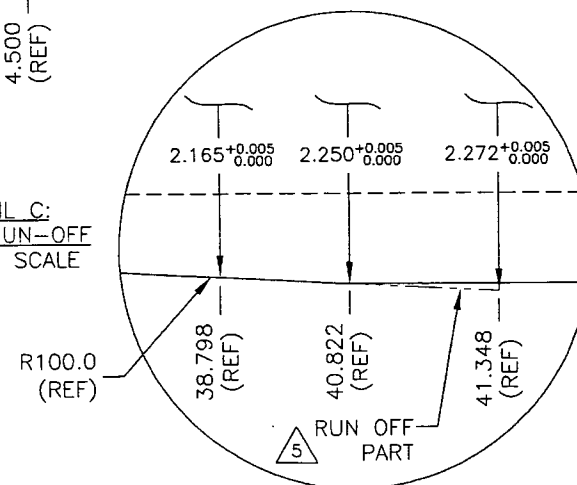


UNDER REVIEW PH
~~PE-01-10 PH~~
~~Re-draw detail F 02.06.06~~

RELEASED
 05.07.26



DETAIL C:
 TAPER RUN-OFF
 NOT TO SCALE



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DESIGN	DRAWN BY	DART	DART AEROSPACE LTD. HAMMERSBURT, ONTARIO, CANADA
PH	PH		
CHECKED # DS	APPROVED # DS	DRAWING NO. D407-667-145	REV. B SHEET 3 OF 3
DATE 05.07.26	TITLE CROSSTUBE ASS'Y (407 HIGH FWD)	SCALE 1:1	

NO. 36158
 WORK ORDER
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 UNCONTROLLED COPY
 ENGINEERING
 RETURN TO
 SHOP COPY

YELLOW

(YFSY)

FED. I.D. #44-0594706

CONSIGNEE
DELIVERY
RECEIPT

12/10/07

06:09 345

FREIGHT BILL NUMBER

705-311078

2

CHECK
DIGIT

DATE: 12/05/07

DEST/ORIG: DTW/LAF

SPANT AEROSPACE LTD

1170 ABERDEEN ST

MANKESBURY ON K6A 1K7

IRVING GOLDEN 613-632-5200

SHORE HELICOPTER SUPPORT SERV

1004 BURGESS DR

CARLSBAD LA 70518

SHIPPER'S RNM ***337-819-0500

N/A BLU

SHIPPER'S N/A BLU

PKG

DESCRIPTION

CLASS

WEIGHT LBS.

RATE

EXTENSIC

*** EXACT EXPRESS: TIME ARRIVED AT CONSIGNEE TO MAKE DELIVERY

2 BOXES AIRCRAFT PARTS CL 200

200

340.4

2 BOXES AIRCRAFT PARTS CL 70

80

140.0

OVER DIMS TIER 1 GROUND-COL

BORDER CHARGE US-CAN GROUND-COL

FUEL SURCHARGE-EE-25.0% INCREASE-COL

725.0

85.1

SINGLE SHIPMENT

*** DIMENSION INFO ***

PIECES

LENGTH

WIDTH

HEIGHT

2

150

12

6

2

20

12

34

RECEIVED IN GOOD CONDITION AND SERVICE AUTHORIZED EXCEPT AS NOTED BY

C.O.D.
AMT: PAYABLE BY CASH OR CERTIFIED
CHECK UNLESS OTHERWISE NOTED

TTL WEIGHT LBS.

PPD/COLL

TTL FREIGHT CH

SITE
DELIVERYLIFT
GATE# PIECES
SORT & SEGRESIDENTIAL
DELIVERYCONSTRUCTION
SITE DELVWAIT TIME
START
ENDAM/PM
AM/PM

AUTHORIZED PHONE #

COL NEXT PAGE

Date: Wednesday, 4/2/5/2007 3:43:45 PM
User: Kim Johnston

Process Sheet

Customer : CC-DAR01 Dart Aerospace Ltd. Drawing Name : D407667105A
Job Number : 36158
Estimate Number : 10804
P.O. Number :
This Issue : 12/5/2007 S.O. No. :
Prsht Rev. : NC Part Number : D407667105
Drawing Number : REWORK
First Issue : / / Type : LANDING GEAR Project Number :
Drawing Revision :
Previous Run : 36157 Material :
Due Date : 12/12/2007 Qty: 1 Um: Each
Written By :
Checked & Approved By : 07.12.05
Comment :

Additional Product

PAPERWORK + LABELS CHG 002
07.12.06

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

REMOVE FROM STOCK:

1 X D407-667-105A B34328

STRIP P746 ARMOR SHIELD

2.0 D407667105A Crosstube Installation W/ armour shield



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Crosstube Installation W/ armour shield

3.0 SPRAY PAINTING SPRAY PAINTING



Comment: SPRAY PAINTING
RE-SPARY PAINT CROSSTUBE
WHITE IMRON PER QSI 005 4.2

REFERENCE ONLY

4.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

5.0 LANDING GEAR 1 LANDING GEAR RESOURCE 1



Comment: LANDING GEAR RESOURCE 1
REASSEMBLE PER DRWG D407-667-105
USING EXISTING HARDWARE
RECORD ANY NEW HARDWARE: